

Work Order ID 138595

138595

Page 1

Tuesday, November 03, 2015 11:47:50 AM

Item ID: D6101-017 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle Billet
Start Date: 11/3/2015 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 11/3/2015 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: MCS Date: NOV 03 2015 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D6101	B								

100

100

Purchasing

Purchasing

PURCHASING

Memo

Issue P/O: 30362

- a) Description: Alluminum billet
- b) 6.350" x 6.250" x 2.250" thick (+0.030 / -0.000)
- c) Tolerance on all dimensions are +0.030/-0.000"
- d) Grain direction along 6.350" length
- e) Material: 7075-T7351 (QQ-A-250/12)
- f) Material certification required

0.00

0.00

CY NOV 04 2015 12

110

110

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

Memo

Ensure material certification is attached

0.00

0.00

12x 80 15-11-23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																								
Description Work Order Deviation				Disposition				Completed By																																																							
4/15								Lead hand / Supervisor Approval Verification																																																							
								QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
OTHER : _____																																																															

Work Order ID 138595

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Tuesday, November 03, 2015 11:47:50 AM

Item ID: D6101-017 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle Billet
 Start Date: 11/3/2015 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 11/3/2015 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
120									DAS 14 9-59
QC	Memo	0.00				12	0		15/11/23
Quality Control	Ensure Material certification comply to Dwg D6101								
130	Identify as per dwg & Stock Location: <u>MAT046</u>	0.00							
130									DAS 14 9-59
Packaging	Memo	0.00				12	0		15/11/23
Packaging	LOCATION: MAT046								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.02				MCS		15-11-24	
Quality Control									

SAK 0151123

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Tuesday, November 03, 2015 11:47:53 AM

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138595

D6101-017

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-017P		Purchased	No			110	Each	0.0000	1	12			
D6101-017P									**	12x 8015-11-23			
ALUM BILLET													

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

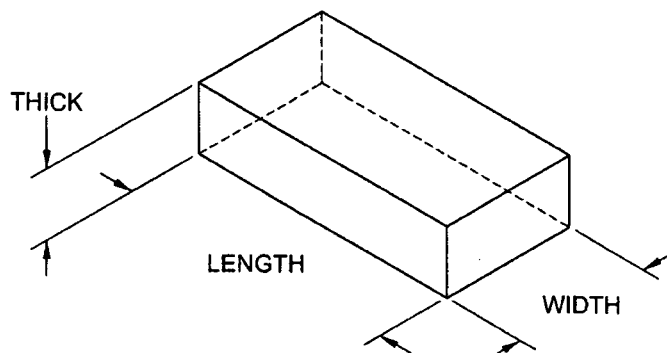
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

SPECIFICATION CONTROL DRAWING



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

B ACCEPTABLE SPECIFICATIONS FOR 7075-T7351 ALUMINUM ARE AMS-QQ-A-250/12, QQ-A-250/12, OR ASTM B209

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length
D6101-015	7075-T7351 (QQ-A-250/12)	9.450	6.250	2.500	Along 9.450 Length
D6101-017	7075-T7351 (QQ-A-250/12)	6.350	6.250	2.250	Along 6.350 Length

RELEASED
09/07/15/W

COPY TO
ENGINEERING
LEAD COPY
OFFICE
138595 M/C
15-11-03

B	ADDED D6101-015/-017, ADD ASTM B209	RF	09.04.23
A	NEW ISSUE	CP	01.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D6101	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE BILLET, 7075	NTS
DATE	09.04.23	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO30362

Purchase Order Date 11/4/2015

PO Print Date 11/4/2015

Page Number 1 of 2

Order From :
METAUX CASTLE
P.O. BOX 4090 STN A
TORONTO, ONTARIO M5W OE9
CANADA

VU-MET002

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED

Contact Name
Vendor Phone

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency USD
FOB Destination-Collect

Ship To Contact
Ship To Phone
Ship Via: Yours ppd
Ship Acct:

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	D6101-017P	ALUM BILLET	11/19/2015 Yes 11/19/2015		12.00 Each	\$64.75	\$777.00
	AS PER DWG D6101 REV. B B138595 SIZE: 6.350" X 6.250" X 2.250" THICK GRAIN DIRECTION ALONG 6.350" LENGHT MATERIAL: 7075-T7351 QQ-A-250/12 TOLERANCE AS PER QUOTE +.030"/-.000"						

SP15-11-23

Line Total: \$777.00

2	D6104-003P	17-4 SS Roundbar 3.25"Od	11/19/2015 Yes 11/19/2015		10.00 Each	\$36.25	\$362.50
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AS PER DWG D6104 REV. B
B138596
SIZE: 3.25" X 3.80" LONG
MATERIAL: 17-4 PH AS PER AMS 5643 OR AISI 630

Line Total: \$362.50

Note:

11/4/2015

**Castle Metals®**

A. M. Castle & Co.

PACKING SLIP/
CERTIFICATE OF CONFORMANCE

Page 1 of 2

Shipment No:2794045

Ship From: A. M. Castle & Co. TORONTO - CASTLE METALS 2150 ARGENTIA ROAD MISSISSAUGA, ON L5N 2K7		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		Ship To: DART AEROS,HAWKESBURY,O N,CAN 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CAN		Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date Shipped 18-NOV-2015	F.O.B. ORIGIN	Freight Terms Prepaid		Carrier MANITOULIN		BOL No 2794045-2	

Shipment Details	Final Destination Branch - TOR
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Order No 4124807	Line No 1	Item No 750704.MO	Description 2.2500.PL.7075.T7351.ALUMINUM.US1.48.5000.144.5000 CUT RECTANGLE TO 6.25 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 6.35")) X 6.35 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 6.35")) - ALUMINUM PLATE SAW SPECIFICATIONS: AMS-QQ-A-250/12 Email P/s and certs to: clavoie@dartaero.com ALL PAPERWORK MUST FOLLOW ORDER / CUSTOMER MUST RECEIVE AT TIME OF DELIVERY ALL MATERIAL MUST HAVE IDENTIFYING MARKINGS EX:HEAT #S				
Purchase Order No 30362	Part Number YOUR ITEM NUMBER: D6101-017		Ordered Qty 12.00 PCS		Invoice Qty 12.00 PCS		
Details			ALL PAPERWORK MUST FOLLOW ORDER / CUSTOMER MUST RECEIVE AT TIME OF DELIVERY ALL MATERIAL MUST HAVE IDENTIFYING MARKINGS EX:HEAT #S SHIP TO CASTLE, TORONTO (MISSISSAUGA) CUSTOMS BROKER: GEORGE H. YOUNG END USER: DART AEROSPACE END USE: COMMERCIAL AIRCRAFT PARTS SAS-11-23.				
Delivery No.	Mill	Heat Number	Mech Id	PCS	Width (IN)	Length (IN)	Shipped Qty(LBS)

These commodities, technology or software were exported from the United States in accordance with the Export Administration Regulations. Diversion contrary to US law prohibited.
Date Printed: 18-NOV-2015 05:02:01 PM



Castle Metals®

A. M. Castle & Co.

PACKING SLIP/
CERTIFICATE OF CONFORMANCE

Page 2 of 2

120241412	KAISER ALUMINUM	 1 4 6 2 3 5 B 7 1		12			110.3444
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These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.

We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.

Reviewed by Authorized Castle Metals Representative:

Date:

Name:

NOV 18 2015



SP 15-11-23

SHIP TO:

A M CASTLE & CO
14001 ORANGE AVE
P.O. BOX 1402
PARAMOUNT, CA 90723

KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

SOLD TO:

AM CASTLE & CO- SOLD TO
1420 KENSINGTON RD
SUITE 220
OAK BROOK, IL 60523

CERTIFIED TEST REPORT

Serial Number

4391940

CUSTOMER PO NUMBER: 339156		WORK PACKAGE:		CUSTOMER PART NUMBER: 750794		SHIP RUN/LOAD: 103342/5		GOVT CONTRACT NUMBER:		
KAISER ORDER NO: 1196578		LINE ITEM: 1	SHIP DATE: 1-OCT-2015		ALLOY: 7075	CLAD: BARE	TEMPER: T7351	PRODUCT DESCRIPTION: KaiserSelect Plate		
WEIGHT SHIPPED: 3286 LB		QUANTITY: 2 PCS EST.		TRUCK B/L #: 2056220		GAUGE: 2.2500 IN (57.1500 MM)		DIAMETER/WIDTH: 48.500 IN (1231.8 MM)		LENGTH: 144.500 IN (3670.3 MM)

MHU 1934342: LOT 14623587, 2 pieces;

Certified Specifications

AMS 4078/RevJ
ASTM B 209/Rev14
BSS 7055/RevB
DPS 4.713/RevAK
GSS16100/RevG/Amd1

AMS-QQ-A-250/12/RevA
ASTM-B 594/Rev13
CMMP 025/RevU
EAC MS1011/RevE
MMS 159/RevT

AMS-STD-2154/RevA
BAC 5439/RevJ
CSTI 006/RevE
GAMPS 9101/RevB/AmdSCN1
PS 21211/RevM

Test Code: 4297

Test Results

Lot: 14623587 Cast 874

Drop 21

Ingot 4



Melted in USA

(ASTM E8/B557)

(EN 2002-1)

Tensile:	Temper: T7351	Dir / # Tests LT / 2 (Min:Max)	Ultimate KSI (MPA) 70.3 : 70.5 (485 : 486)	Yield KSI (MPA) 59.0 : 59.2 (407 : 408)	Elongation % 12.1 : 12.2
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(ASTM E1004)

(EN 2004-1)

Conductivity %IACS :	39.6 Min	39.7 Max
(MS/M) :	23.0 Min	23.0 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual(wt%)	0.07	0.14	1.6	0.03	2.5	0.19	5.8	0.03	0.01	0.02	TOT 0.05

KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4391940

ALLOY LIMITS

	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
7075												
MIN(wt%)	0.00	0.00	1.2	0.00	2.1	0.18	5.1	0.00	0.00	0.00	EACH	0.05
MAX(wt%)	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.05	TOT	0.15

Aluminum Remainder

ORDER COMMENTS

AMC CA-154138 R 6
AMS 4078, AMS QQ-A-250/12, AMS STD-2154, A
STM B209, ASTM B594, BS
S 7055, CMMP 025, CSTI 006, DPS 4.713, GAMP
S 9101, MMS 159, PS 212

11

TEST NOTES

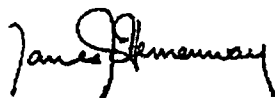
Metal represented by this test report was 100% immersion ultrasonically tested from one side with 3mm dead zones top and bottom and meets the Class A and Class B requirements of all specifications referenced on this test report. No surface marking of sonic indications is performed.

CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC (Kaiser), is ISO-9001:2008/AS9100C certified and hereby certifies that all material shipped under this order:

- has been inspected, tested, and found to be in conformance with the requirements of the specifications indicated herein. For material thicknesses outside specification limits, mechanical properties are as shown herein and chemical composition meets specification requirements.
- was melted in the United States of America or a qualifying country per DFARS 225.872-1(a), was manufactured in the United States of America, and meets the requirements of DFARS 252.225 for domestic content.
- has been thermally processed in compliance with AMS 2772, where applicable.
- is mercury free, within the limits of detection of ASTM E1251 (< = 1 ppm).
- is in compliance with RoHS 2, European Union Directive 2011/65/EU.
- is in compliance with and regularly monitors any updates to the European Chemical Agency, ECHA, REACH regulations, (EC) n°1907/2006.
- is free of Conflict Minerals, as defined in Section 15.2 of the Dodd-Frank Act.

Any warranty is limited to that shown on Kaiser Aluminum's standard general terms and conditions of sale. Test reports are on file, subject to examination. Test reports shall not be reproduced except in full, without the written approval of the Kaiser Aluminum laboratory. The recording of false, fictitious or fraudulent statements or entries on the certificate may be punished as a felony under federal law.



JAMES HEMENWAY, LABORATORIES SUPERVISOR



www.abf.com

XXXXCANF



SHIPPER'S NO. 2784479-2		CRN SEE BELOW		11/18/15 06:50		PAGE 1 OF 2	
PICK UP DATE	CODE TO	PO. NO.	NO. OF P.O.'S	ROUTING	FREIGHT BILL NO.		
11/10/15	339D	SEE BELOW		LBH-TOR	161530998		
SHIPPER AM CASTLE & CO 14001 ORANGE AVENUE PARAMOUNT CA 90723				CONSIGNEE 003079-0026 A.M CASTLE & CO (CANADA) INC TORONTO-CASTLE METALS 2150 ARGENTIA ROAD MISSISSAUGA ON L5N2K7 CA			

PIECES	DESCRIPTION	WEIGHT (LBS.)	RATE	CHARGES
3 BX	*NOTES FOLLOW: *ALL LOADS MUST BE TARPED *Tarped Flat Deck City Delivery *location. Over 400 pounds and 8' *long require flat deck delivery. *Load long bars on wood *pallet for delivery. *CCN:2604PARS161530998 *TRAN:10348117445755 TOTAL IND PIECES: 3 ALUMINUM ARTICLES, NOI, IN BXS OR CRTS, 30 PCF OR GRTR, CL 60 ITEM 013120-11 DUNNAGE ITEM 029960-00V / CROSS-BORDER ADMINISTRATIVE FEE	1,124 108		
BILL TO SFB 305692-P001		COD AMOUNT RB 24371 TAR CCZ9910 OZIP 90723 DZIP L5N2K7 SPEC. HAND.		PAY THIS AMOUNT
CUBE 0022 DELIVERY DUE WED 11/18 DELIVERY DATE		PRIOR PRO DATE		REMIT TO
DRIVER		YOUR ACCEPTANCE OF DELIVERY IS SUBJECT TO ABF 111 SERIES TERMS. X BY (CUSTOMER'S SIGNATURE)		
CONSIGNEE				



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XXXXCANF



SHIPPER'S NO. 2784479-2		CRN SEE BELOW		11/18/15 06:50		PAGE 2 OF 2	
PICK UP DATE	CODE TO	PO. NO.	NO. OF P.O.'S	ROUTING	FREIGHT BILL NO.		
11/10/15	339D	SEE BELOW		LBH-TOR	161530998		
SHIPPER AM CASTLE & CO 14001 ORANGE AVENUE PARAMOUNT CA 90723				CONSIGNEE 003079-0026 A.M CASTLE & CO (CANADA) INC TORONTO-CASTLE METALS 2150 ARGENTIA ROAD MISSISSAUGA ON L5N2K7 CA			

PIECES	DESCRIPTION	WEIGHT (LBS.)	RATE	CHARGES
3	/ PACKING LIST REQUIRED /// FUEL SURCHARGE /// GOODS & SERVICES TAX CRN: 1111654619 CRN: 4123012 CRN: 4124807 PO: 30035 PO: 30362 PO: 60181289 PCS 3 WEIGHTM. CASTLE & CO. ABF MEASURED CUBE: 22.220 CUB TORONTO	PKG FSC GST		
TOTALS FREIGHT BILL NO		161530998		1,232 PREPAID
BILL TO SFB 305692-P001		COD AMOUNT RB 24371 TAR CCZ9910 OZIP 90723 DZIP L5N2K7 SPEC. HAND.		PAY THIS AMOUNT
CUBE 0022 DELIVERY DUE WED 11/18 DELIVERY DATE		PRIOR PRO DATE		REMIT TO
DRIVER		YOUR ACCEPTANCE OF DELIVERY IS SUBJECT TO ABF 111 SERIES TERMS. X BY (CUSTOMER'S SIGNATURE)		
CONSIGNEE				

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D6101-017
DATE: 15/11/23

PO / BATCH NO: 30362/138595

MATERIAL CERT REC'D: yes
QUANTITY RECEIVED: 12
QUANTITY INSPECTED: 12
QUANTITY REJECTED: _____

THICKNESS ORDERED: 6.35X6.25X2.250
THICKNESS RECEIVED: 6.35X6.25X2.30
SHEET SIZE ORDERED: _____
SHEET SIZE RECEIVED: _____

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y ☒	
CORRECT FINISH	☒ N	
CORROSION	Y ☒	
CORRECT GRAIN DIRECTION	☒ N	
CORRECT MATERIAL	☒ N	
CORRECT THICKNESS	☒ N	
PHOTO REQUIRED	Y ☒	
CORRECT MATERIAL	☒ N	
CORRECT REF # TO LINK CERT	☒ N	
CORRECT MATERIAL IDENTIFICATION	☒ N	
CORRECT M# ON THE MATERIAL	☒ N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y ☒	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y ☒	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW				
TYPE OF MATERIAL	HRC	HRB	DUR A	DUR D
SIZE OF TEST SAMPLE				
HARDNESS / DUROMETER READING				

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>DAS</u> <u>14</u> <u>3-52</u>	SIGNED OFF BY: _____		
DATE: <u>15/11/23</u>	DATE: _____		

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

MATERIAL RECEIPT INSPECTION FORM

INSTRUCTIONS FOR INSPECTING BAR, TUBING, ROUND, & SHEET STOCK

- 1- VERIFY STOCK TO DART PURCHASE ORDER
- 2- MEASURE ALL DIMENSIONS FOR EACH PURCHASED STOCK
 - a. WIDTH, THICKNESS, DIAMETER, WALL THICKNESS & LENGTH
- 3- VERIFY CONDITION OF MATERIAL i.e. DAMAGED, CORRODED, etc.
- 4- VERIFY THAT SUPPLIER HAS A NUMBER (HEAT #) ON ITS RECEIVING REPORT TO LINK TO MATERIAL CERTS
- 5- VERIFY MATERIAL CERTS ARE CORRECT TO THE DART PO INSTRUCTIONS
- 6- REMOVE / CUT A PIECE OF MATERIAL FOR SAMPLE HARDNESS TESTING

INSTRUCTIONS FOR INSPECTING SKIDTUBE & STEP EXTRUSION

- 1- VERIFY TO DART SUPPLIED DRAWING
- 2- SAMPLE INSPECT MATERIAL IN BUNDLE TO ENSURE MATERIAL CAN BE RECEIVED INTO DART
- 3- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING
- 4- VERIFY THAT MATERIAL CERTS MATCH TO WHATS CALLED UP ON THE DART DRAWING

AFTER MATERIAL PASSES INSPECTION

- 5- HAVE DART EMPLOYEES START STOCKING MATERIAL BUT REQUEST MIN **20pcs** FOR FULL INSPECTION
- 6- INSPECT ALL DIMS AS PER DRAWING REQUIREMENTS

INSTRUCTIONS FOR INSPECTING CROSS TUBE MATERIAL

- 1- VERIFY MATERIAL CERTS MATCH THE REQUIREMENTS ON THE DART DRAWINGS
- 2- INSPECT MIN. HALF THE BATCH OF EXTRUSION RECEIVED INTO DART
- 3- INSPECT MATERIAL AS PER THE EXTRUSION REPORT
 - a. WALL THICKNESS USING ULTRA-SONIC IN 4 LOCATIONS
 - b. OUTSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - c. INSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - d. STRAIGHTNESS @ CENTER OVER 12" SPAN
 - e. WALL THICKNESS USING TUBE MICROMETER HIGHEST/LOWEST BOTH ENDS
- 4- IDENTIFY EACH TUBE IN SEQUENCE OF INSPECTING (TUBE 1, TUBE2.....) AND W/O# AND PO#
- 5- RECORD ALL FINDINGS ON EXTRUSION REPORT

IF ANY QUESTIONS PLEASE SEE QC COORDINATOR BEFORE GOING FURTHER